

Work Order ID 110161

December-17-13 9:17:02 AM

110161

Page 1

Item ID: D3916-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly

Start Date: 12/17/13 Start Qty: 10.00

10 **42**

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-12-18 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3916	A

100 0.00

100

Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

42 CC 14-1-21

105 QC6- Inspect dimensions to drawing 0.00

105

QC

Quality Control

Memo

0.00

CC 14-01-21

DAS
9
9-89

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/17/13 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 12/17/13 **Req'd Qty:** 10.00

~~*10*~~**Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

**Insp.
Stamp**

Weld per dwg A/R S.S. rod Batch: B123823

0.00

107

Large Fab

Memo

0.00

Large Fab

1- weld bushing as per dwg D3916
2- grind welds flush

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

OC

Memo

0.00

Quality Control

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Item ID: D3916-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly

Start Date: 12/17/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA04</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

PL 14-01-23

MLJ 14-01-24

H 14-01-23

Picklist Print

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Page 1

Work Order ID: 110161
 Parent Item: D3916-041
 Parent Item Name: Rib Assembly

Start Date: 12/17/13
 Start Qty: 10.00
 Required Date: 12/17/13
 Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
 verified by:EC
 IPP Rev:B as per dwg revA 10.03.15

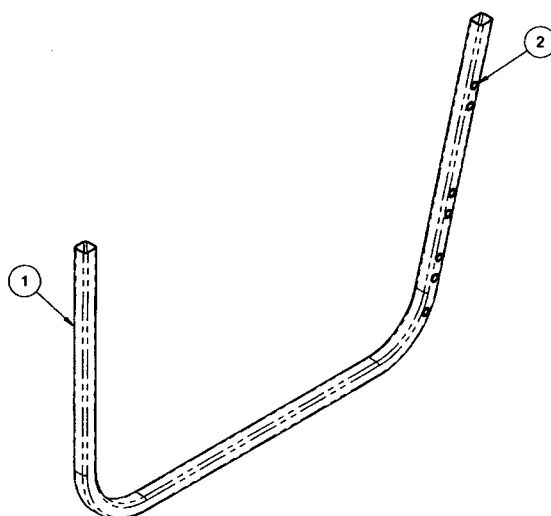
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	135.0000	7	70		CC 14-1-21	

Location	Loc Qty	Loc Code
WA004	135	
102073	1	
106686	44	
107189	12	
107591	74	
108412	4	

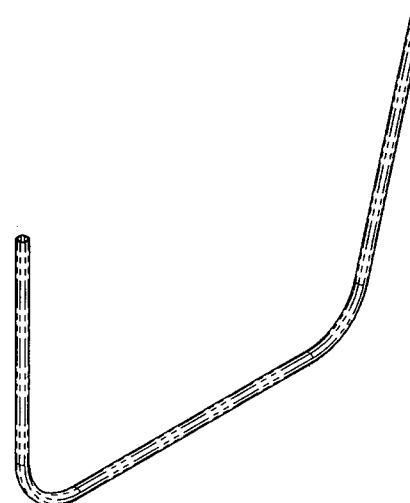
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	928.4540	4.166	43.852632		CC 14-1-21	
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Location	Loc Qty	Loc Code
WA004	928.4540331	
M126039	89.9999331	
M126364	211.2885	
M126900	67.1656	
M127493	560	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



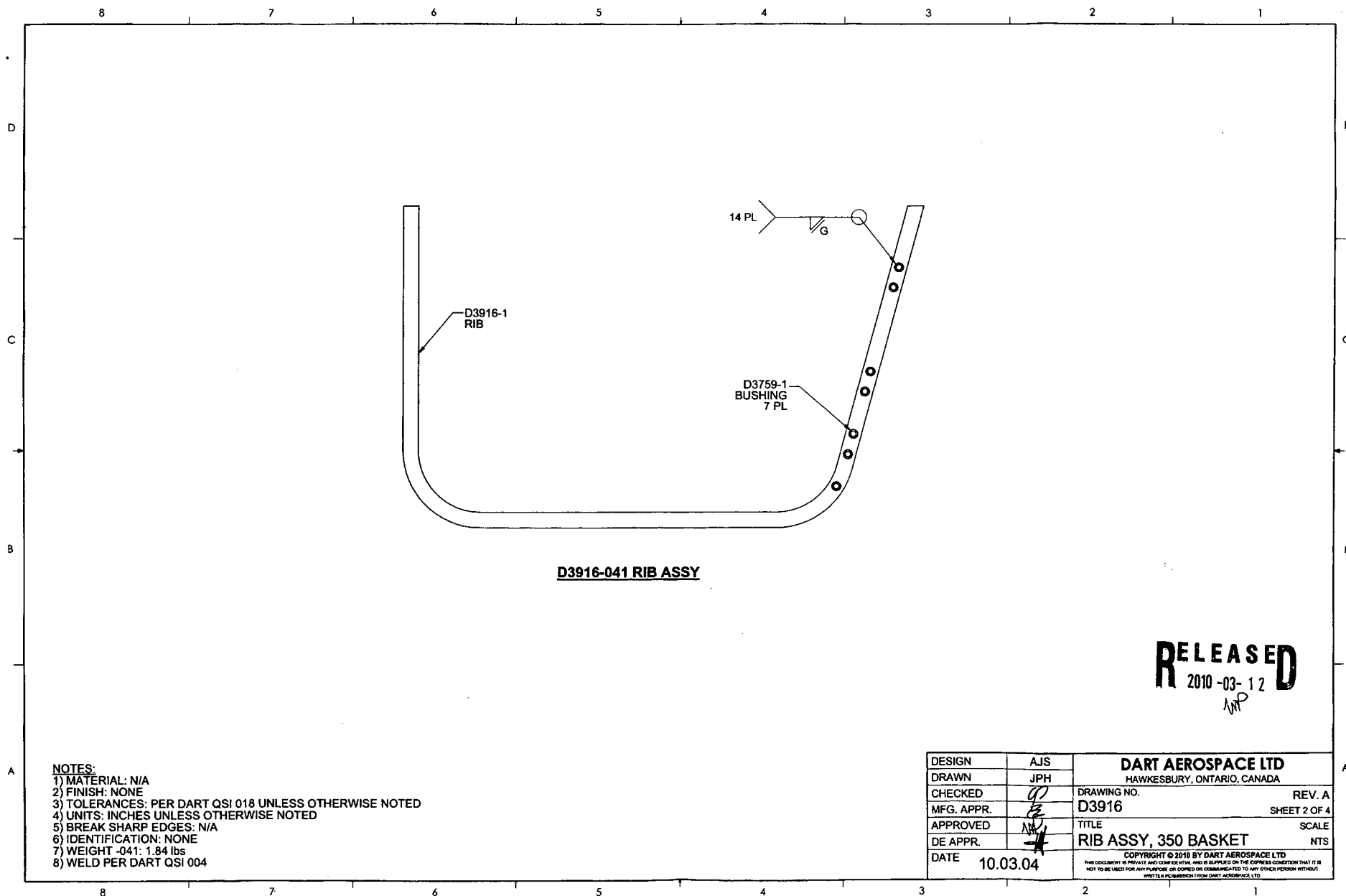
D3916-5 LIGHT RIB

110161
MLJ
13-12-18

OK 10.12.21
UNDER REVIEW
10.12.21
ADDITION OF HOLE + BUSHING
ON D3916-041-1 RIBS.
RELEASED
2010-03-12
JNP

A		NEW ISSUE		JPH		10.03.04	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	
DRAWN	JPH					SHEET 1 OF 4	
CHECKED	JPH	DRAWING NO. D3916				SCALE	
MFG. APPR.	JPH	TITLE				NTS	
APPROVED	JPH	RIB ASSY, 350 BASKET					
DE APPR.	JPH						
DATE	10.03.04						

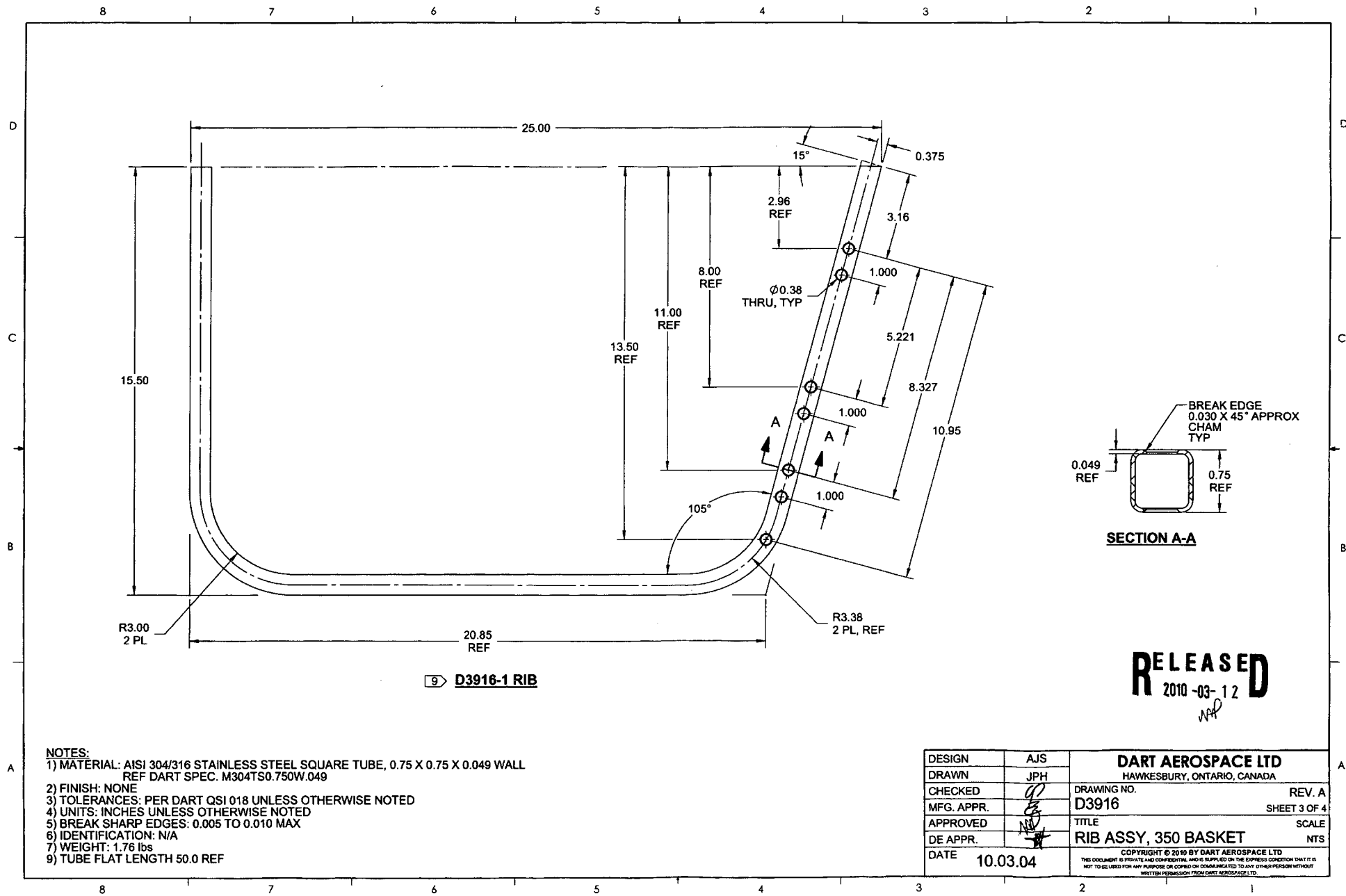
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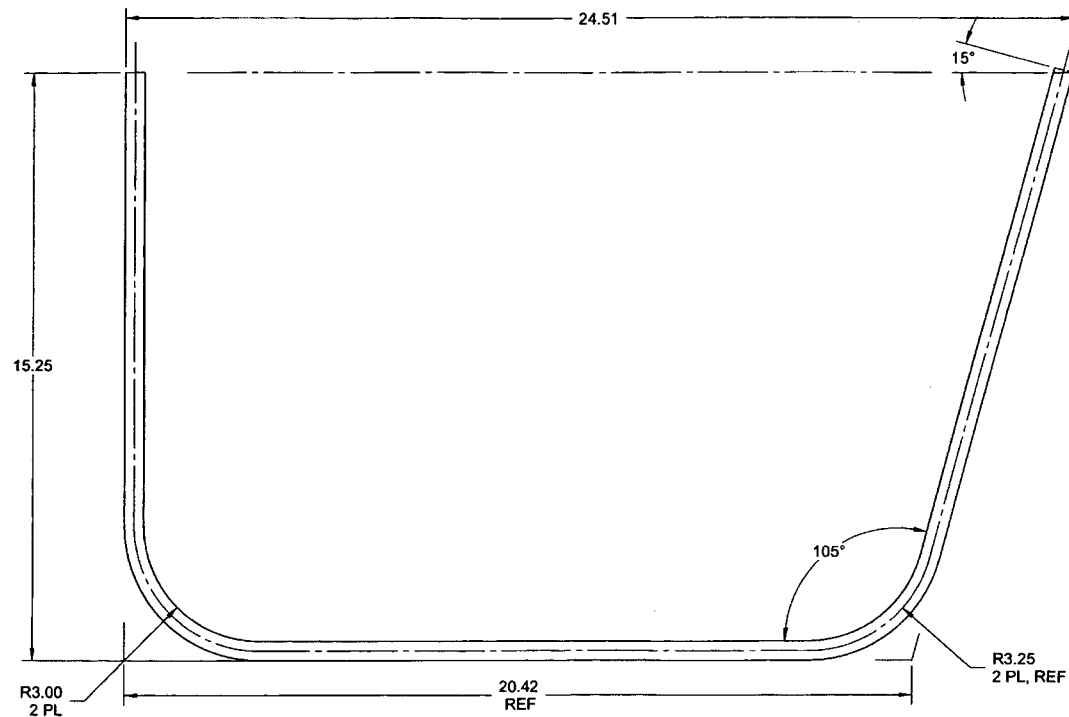


- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT -041: 1.84 lbs
 8) WELD PER DART QSI 004

RELEASED
 2010-03-12
 AMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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9 D3916-5 LIGHT RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

RELEASED
2010-03-12

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MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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